

ABSTRACT

5 The present invention, in a method of casting an
austenitic stainless steel thin strip casting with a
continuous caster wherein mold walls move synchronously
with the casting: provides a production method for
preventing pepper-and-salt unevenly glossy defects
distributed zigzag in the form of spots from appearing on
a steel sheet after cold rolling and cold forming; and is
10 a method for producing an austenitic stainless steel thin
strip casting, characterized by regulating a pressing
force P of mold wall faces against the casting in the
range from more than 1.0 to less than 2.5 t/m, preferably
from more than 1.1 to not more than 1.6 t/m. In the
15 production method: the continuous caster used is a twin-
drum type continuous caster; the drum radius R (m) and
the pressing force P (t/m) of mold wall faces satisfy the
relation $0.5 \leq (\sqrt{R}) \times P \leq 2.0$, preferably $0.8 \leq (\sqrt{R}) \times$
 $P \leq 1.2$; the height of a molten steel pool formed
20 between mold walls is not less than 200 to not more than
450 mm; and in-line rolling is applied during the process
from molding to coiling.

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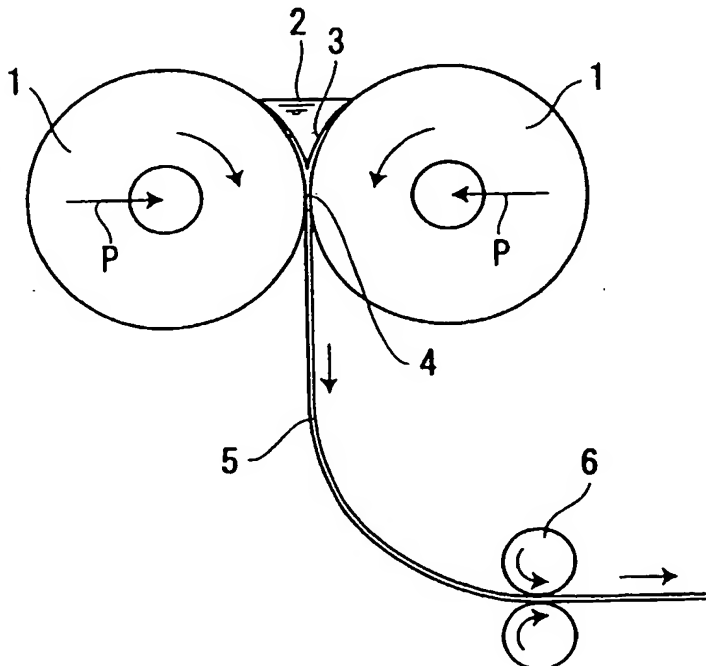
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(54) Title: METHOD OF MANUFACTURING AUSTENITIC STAINLESS STEEL SHEET CAST PIECE

(54) 発明の名称: オーステナイト系ステンレス鋼薄帯状鋳片の製造方法



(57) Abstract: A method of manufacturing, by casting, an austenitic stainless steel sheet cast piece by continuous casting equipment having mold walls moving in synchronism with the cast piece capable of preventing punctate and staggered marbling uneven brightness found on a steel sheet after cold drawing and cold working, characterized in that a pressing force (P) of the surface of the mold walls against the cast piece is more than 1.0 to less than 2.5 t/m, desirably more than 1.1 to 1.6 t/m or less. The continuous casting equipment of a double drum type, wherein a relation between a drum radius R (m) and the pressing force P (t/m) of the surfaces of the mold walls is $0.5 \leq (\sqrt{R}) \cdot P \leq 2.0$, desirably $0.8 \leq (\sqrt{R}) \cdot P \leq 1.2$, the height of a molten steel pool formed between the mold walls is 200 to 450 mm, and an in-line rolling is applied to the cast piece between the mold process and a winding process.

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